Work Order ID   59836

Friday, June 11, 2010 2:38:19 PM

Item ID:	D4017-7	Accept		Setup	Start	
Revision ID:						
Item Name:	Rib				Stop	

Start Date:	6/11/2010	**Start Qty:** 3.00		**Cust Item ID:**		
Required Date: 6/18/2010		**Req'd Qty:** 3.00		**Customer:**		
Reference:						

Approvals: **Process Plan:** _____ **Date:** /0-6-/4   **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run **Start** _____   **Stop** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4017	B								
100		0.00				③			
Large Fab	**Memo**	0.00							
Large Fab	1- Cut tube as per dwg D4017 2- Deburr and remove identify marks	*SAD 10-07-05*							
110	QC5- Inspect part completeness to step on W/O	0.00				⊗×3			
QC	**Memo**	0.00 *S w 6 7 06*							
Quality Control									
120	Identify as per dwg & Stock Location: *WA*	0.00				③			
Packaging	**Memo**	0.00 *SAD 10-07--06*							
Packaging									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:_____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item ID:	D4017-7			Accept		Setup	Start	
Revision ID:								
Item Name:	Rib						Stop	
Start Date:	6/11/2010	**Start Qty:** 3.00			**Cust Item ID:**			
Required Date:	6/18/2010	**Req'd Qty:** 3.00			**Customer:**			
Reference:								

Approvals:	**Process Plan:** _____	**Date:** _____	**Tooling:** _____	**Date:** _____	Run	**Start**	
	QC: _____	**Date:** _____	**SPC (Y/N):** _____	**Date:** _____		**Stop**	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	**Memo**	0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Work Order ID: 59836

Parent Item: D4017-7

Parent Item Name: Rib

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC
per dwg RevA DD 10.03.06 verified by:EC   IPP Rev:C as per dwg RevB
DD 10.04.16 verified by:EC   IPP Rev:B as

Start Date: 6/11/2010   **Required Date:** 6/18/2010
Start Qty: 3.00   **Required Qty:** 3.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
M304TS0.750W.049		Purchased	No			100	f	238.0418	0.0675	0.213158			
304 SQ Tube .75x.75x.049W													

SAD 10-07-05

Location		Loc Qty	Loc Code
MAT		238.0417419	
	113763	0	
	114323	28.3020789	
	114677	14.34201	
	114835	195.397653	
MAT017		3.68448E-05	
	114298	3.6845E-05	

0.2131

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B			Verification	Approval	Approval
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER
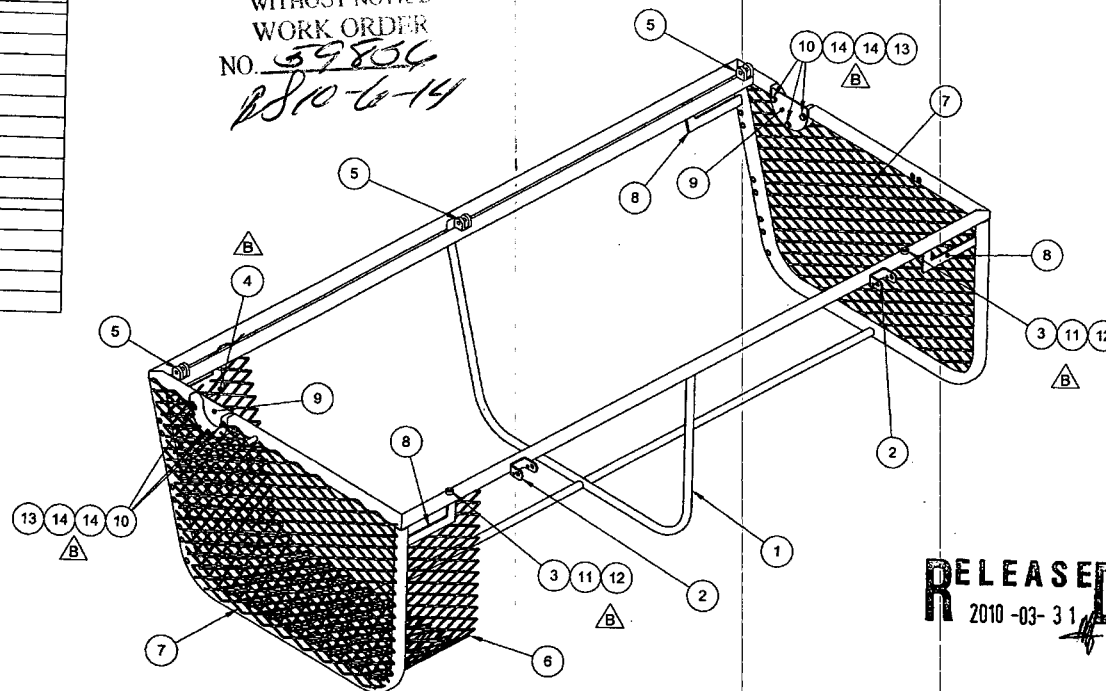
D4017-041 SHORT BASKET BASE ASSY (350)
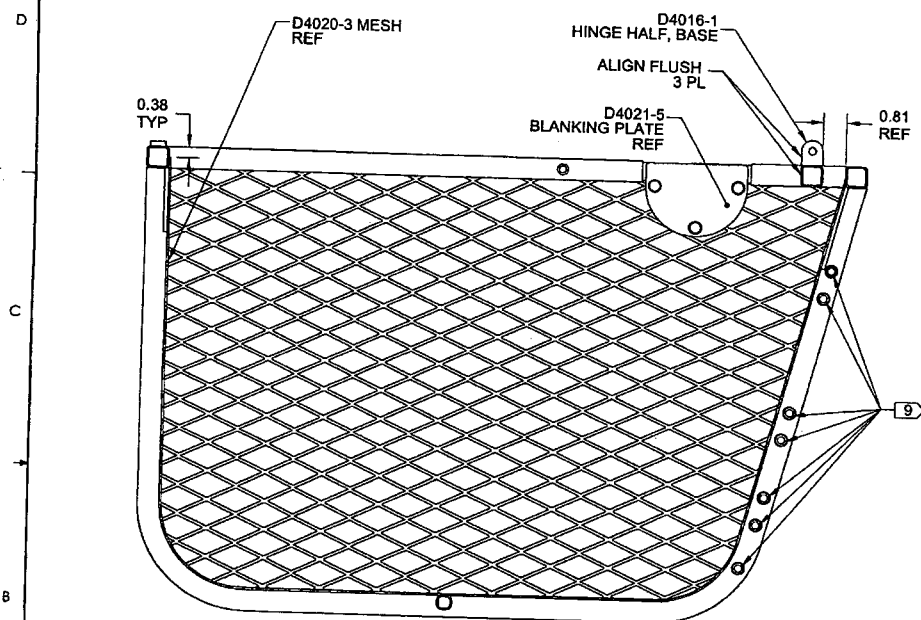(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-31

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT: 28.8 lbs APPROX
8) INSTALL AFTER FINISH
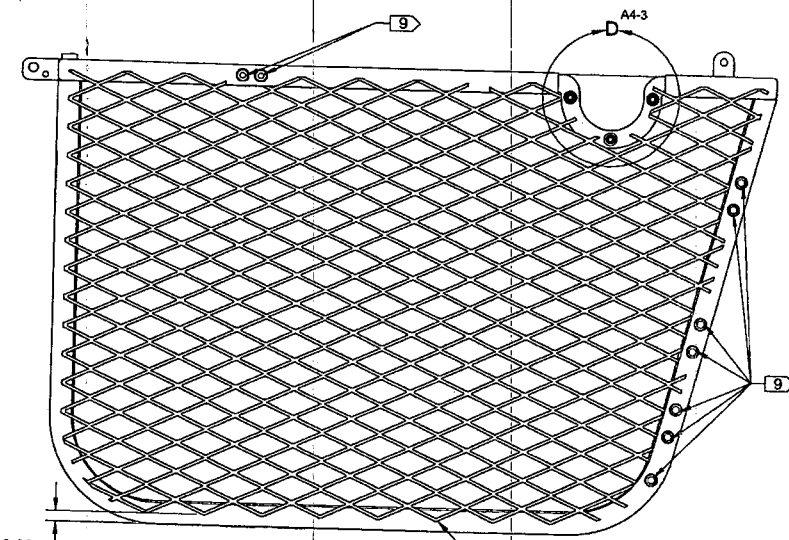9) MASK HOLES PRIOR TO POWDER COAT
10) WELD PER DART QSI 004

B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D8-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3)		JPH	10.03.25
A	NEW ISSUE		AJS	10.03.04
REV.	DESCRIPTION		BY	DATE

DESIGN	AJS	**DART AEROSPACE LTD**		
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.		REV. B
MFG. APPR.		D4017		
APPROVED				SHEET 1 OF 5
DE APPR.		TITLE		SCALE
DATE	10.03.25	SHORT BASKET BASE ASSY (350)		NTS

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C D5-2

D3913-15
WIDE HANDLE PLATE

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

SECTION F-F D5-2
TYPICAL FOR ALL
HANDLE PLATES

△B

D6-2 F

F

C8-2 C

D4020-3
MESH

D4017-101
TUBULAR ASSY

D2931 BUMPER
AN960JD8 WASHER
MS20600AD4W3 RIVET
2 PL ⟨8⟩

10.38 — 34.50

2 PL

D2581
MOUNTING BRACKET
2 PL

D4020-11
END MESH

DETAIL D
A4-3
6 PL ⟨9⟩

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

⟨9⟩

⟨9⟩ 4 PL

TRIM MESH TO
CLEAR BUSHING
Ø0.75

0.38
TYP

0.75
2 PL

A

27.94

D4021-1
HANDLE PLATE

△B

B6-3 A

D4016-1
HINGE HALF, BASE
3 PL

D4021-1
HANDLE PLATE
2 PL

3 PL

B

B2-3 B

D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010 -03- 31

W039839

DESIGN	AJS
DRAWN	JPH
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	10.03.25

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4017   REV. B
SHEET 2 OF 5

TITLE   SCALE
SHORT BASKET BASE ASSY (350)   NTS

D4020-3 MESH
REF

D4016-1
HINGE HALF, BASE

ALIGN FLUSH
3 PL

0.38
TYP

D4021-5
BLANKING PLATE
REF

0.81
REF

9

A4-3

9

9

SECTION A-A A5-2

9

0.38
TYP

D4020-11
END MESH

SECTION B-B A2-2

8
D4021-5
BLANKING PLATE

B AN3-10A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
3 PL

8

wl 039834

RELEASED
2010-03-31

TRIM MESH LOCALLY
∅0.50 - ∅0.60
TO CLEAR FASTENERS

DETAIL D D1-3
B8-2

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	1	D4017-7	RIB
5	2	D4017-9	RIB
6	2	D3916-041	RIB ASSY
7	1	D3916-5	LIGHT RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY

RELEASED
2010 -03- 3 1

56.75

28.00

2 PL

D4017-3
RIB

D4017-7
RIB

D4017-5
HINGE RIB

D4017-5
HINGE RIB
REF

1.56

FLUSH

HOLES THIS
SIDE

BOTH
ENDS

4 PL

10.25
2 PL

D3916-5
LIGHT RIB

SECTION E-E A4-4

25.00

D4034-043
FWD UPPER RIB ASSY

2 PL

2 PL

D4017-1
RIB

E

D4034-041
AFT UPPER RIB ASSY

2 PL

16.25

16.25
REF

D3916-041
RIB ASSY

D4017-9
RIB

C1-4 E

D4017-9
RIB

D3916-041
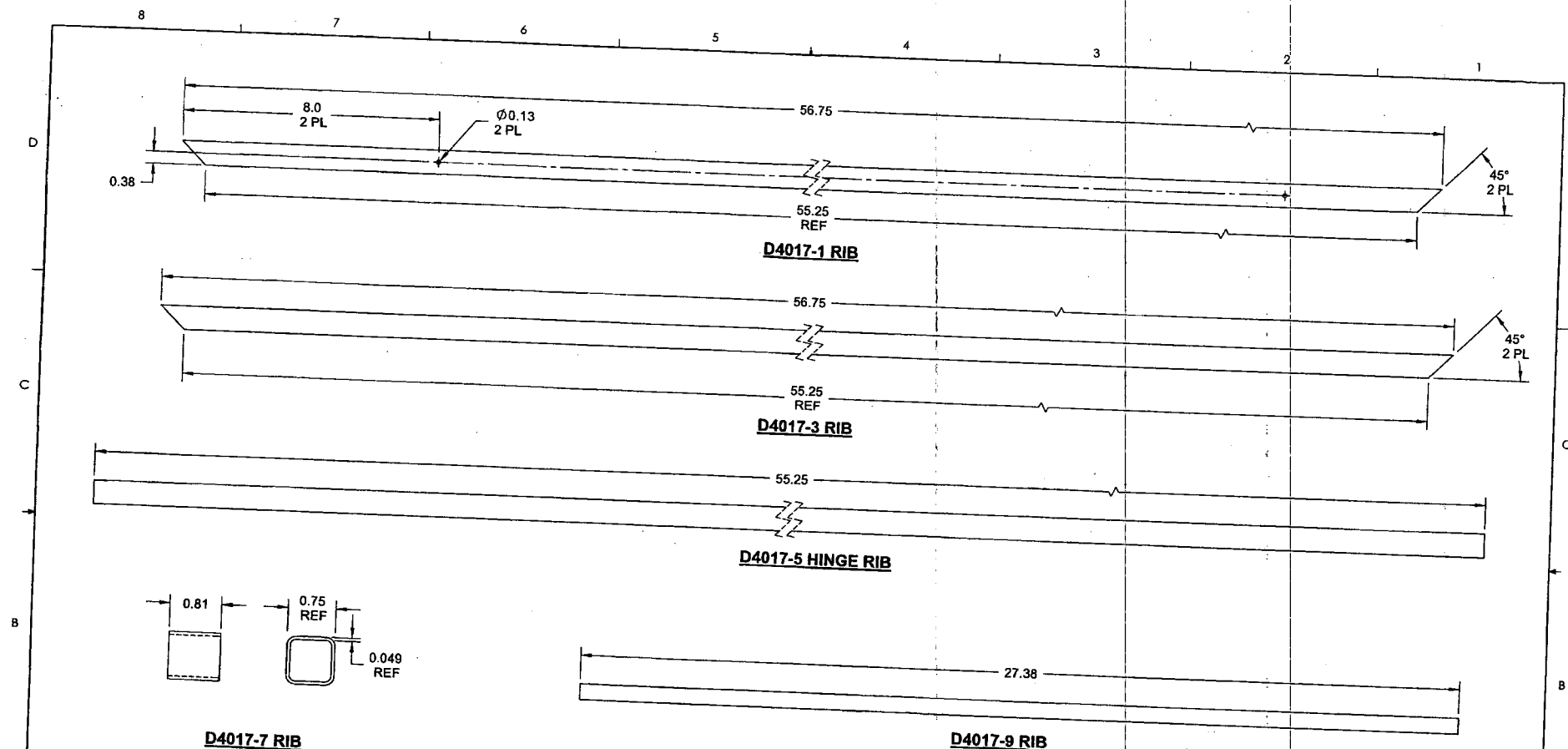RIB ASSY

28.13

〈8〉 **D4017-101 TUBULAR ASSY (350 SHORT BASKET)**
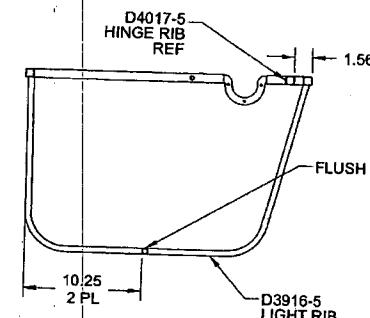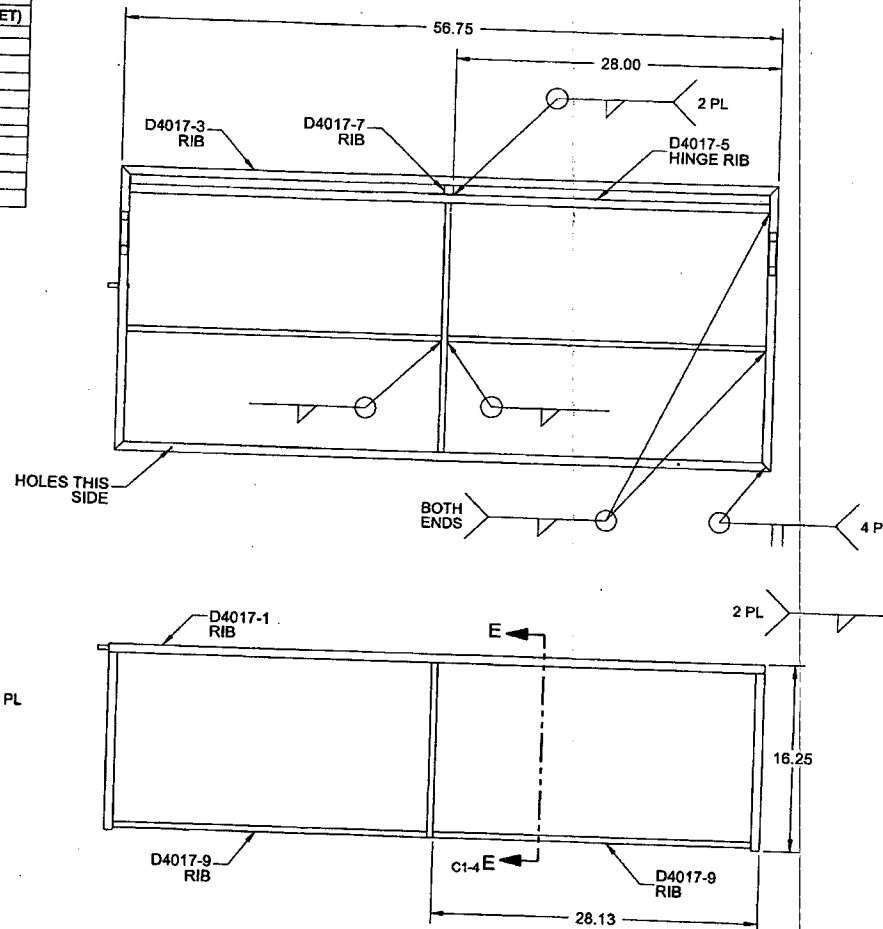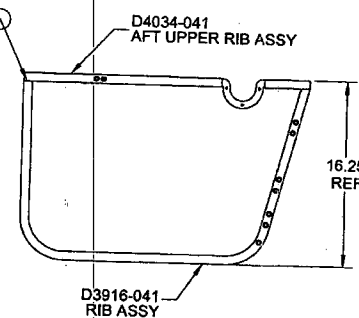
NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 15.26 lbs
8) TOLERANCE FOR XX.XX DIMENSIONS ±0.06 FOR D4017-101
9) WELD PER DART QSI 004

W05986

DESIGN	AJS	**DART AEROSPACE LTD**	
DRAWN	JRH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		D4017	REV. B
APPROVED			SHEET 4 OF 5
DE APPR.		TITLE	SCALE
DATE	10.03.25	SHORT BASKET BASE ASSY (350)	NTS

8.0
2 PL

Ø0.13
2 PL

56.75

45°
2 PL

0.38

55.25
REF

D4017-1 RIB

56.75

45°
2 PL

55.25
REF

D4017-3 RIB

55.25

D4017-5 HINGE RIB

0.81

0.75
REF

0.049
REF

27.38

D4017-7 RIB

D4017-9 RIB

NOTES:
1) MATERIAL -1 THRU -7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
   REF DART SPEC. M304TS0.750W.049

   -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
   REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: SEE ASSEMBLED WEIGHTS

WO 59884

RELEASED
2010 -03- 31

DESIGN	AJS	**DART AEROSPACE LTD**	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		D4017	REV. B
APPROVED		TITLE	SHEET 5 OF 5
DE APPR.		SHORT BASKET BASE ASSY (350)	SCALE NTS
DATE	10.03.25		